

Work Order ID 122257

September-24-14 7:42:17 AM

Report
122257

Page 1

Item ID: D4354-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bearpaw Wearplate Assembly

Stop

NS2

Start Date: 7/14/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/14/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: *[Signature]*

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4354

b

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4354-1)

Dwg Rev: _____

Prog Rev: _____

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

Work Order ID 122257***122257***

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Item ID: D4354-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bearpaw Wearplate Assembly

Stop ***NS2***

Start Date: 7/14/14

Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/14/14

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: _____

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

Picklist Print

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Work Order ID: 122257

122257

Parent Item: D4354-041

D4354-041

Parent Item Name: Bearpaw Wearplate Assembly

Start Date: 7/14/14

Required Date: 7/14/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.04.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4379-1		Manufactured	No			130	Each	106.0000	10	40			

D4379-1

Wearplate Cup

Location

Loc Qty

Loc Code

WA002

106

111025

17

116048

75

117086

14

M304S16GA

Purchased

No

100

sf

515.5870

0.9223

3.883368

M304S16GA

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

340.587

M127821

71.317

M129192

0.17

M129449

269.1

TPI

175

M129545

175

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4354-041	429 BEARPAW WEARPLATE ASSEMBLY
1	1	D4354-1	429 BEARPAW WEARPLATE
2	10	D4379-1	WEARPLATE CUP
3	A/R	2059B	HARDCOAT

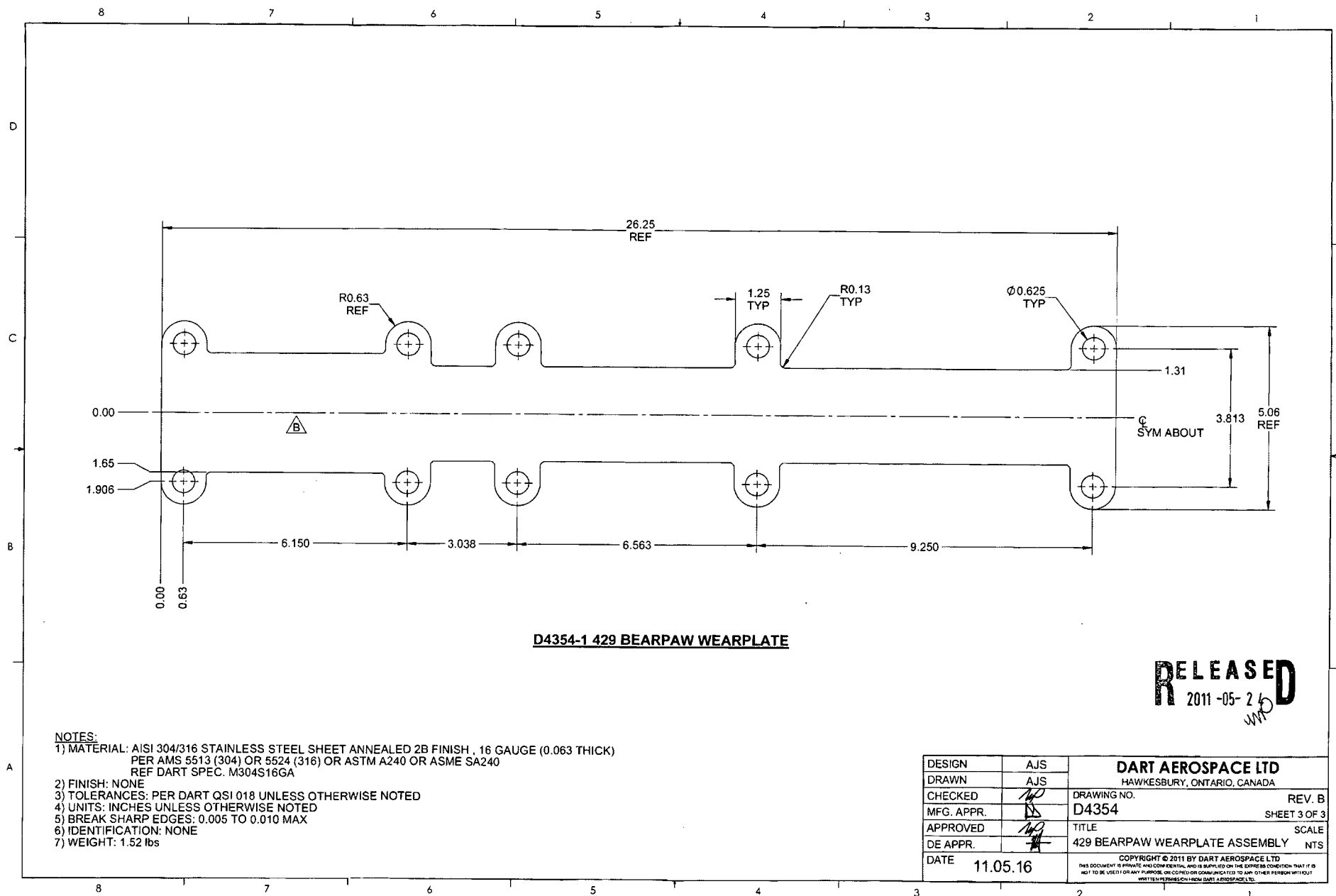
D4354-041 429 BEARPAW WEARPLATE ASSEMBLY

RELEASED
2011-05-24

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4354-041" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 1.76 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 12 PL

B	SHT 3 LIGHTENING HOLES DELETED. SHT 2 ZONE B1 & B5 HARDCOAT RELOCATED. REASON: PROTECTION OF BEARPAW.	AJS	11.05.16
A	NEW ISSUE	AJS	11.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4354	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	429 BEARPAW WEARPLATE ASSEMBLY	NTS
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RELEASED
2011-05-26
WM

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.52 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4354	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	429 BEARPAW WEARPLATE ASSEMBLY	NTS
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